

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011421**Date Inspected:** 01-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** LI Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed U-Rib dimensional survey along with QA inspector (Mr.Manikandan) for below segment.

Reports forwarded to team leader for further action

6AW-6BW

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (6AW-6BW)**

This QA inspector observed, Repair welding of weld joint – SEG-029A-004, ZPMC qualified Welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW), ZPMC CWI is identified as Mr.Li Yang. The Welding Repair Report (WRR) was B-WR8922.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Segment-5CE

This QA inspector observed, Repair welding of weld joint – SEG-026A-008, ZPMC qualified Welding personnel identified as 220067 perform Shielded Metal Arc Welding (SMAW), ZPMC CWI is identified as Mr.Li Yang. The Request for Information (RFI) was 001938R01 (Longitudinal Diaphragm to Bottom Panel).The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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